



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

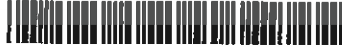
D3235-1
Job Sheet 200976



Part No: D3235-1

Job Qty: 50 pcs

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/20/19

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 11/4/19

Description:

Type: SOLD

Note: D3235 REV.A IPP A 04.04.19 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	50 pcs		11/4/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
120	Packaging 2-1 - Receive - B4B	50 pcs		11/4/19	0.00	0.00	Packaging 2 - 1 - B4B		DP SEP 24 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		DP SEP 24 2019
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		



Container No: S216668



Part: D3235 - 1

Job No: 200976

Serial No/Batch: S216668

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/24/19

Plex 9/20/19 9:11 AM Dart.Renwick.Jennifer

					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					QC 6 - 9	
					QC 6 - 68	
130 QC 6	50 pcs	11/4/19	0.00 0.00		QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
140 Handfinish - 1-1 Chemical- B4B	50 pcs	11/4/19	0.00 0.40		Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 -	

DAS
81
9-89

OCT 02 2019

NR.

				B4B		
				Handfinish - 1 - 22 - B4B		
150	QC 3	50 pcs	11/4/19	0.00	0.00	QC 3 - 10
						QC 3 - 13
						QC 3 - 15
						QC 3 - 17
						QC 3 - 18
						QC 3 - 2
						QC 3 - 28
						QC 3 - 3
						QC 3 - 30
						QC 3 - 34
						QC 3 - 36
						QC 3 - 41
						QC 3 - 51
						QC 3 - 58
						QC 3 - 59
						QC 3 - 68
						QC 3 - 9
						QC 3 - 40
						QC 3 - 19
						QC 3 - 43
						QC 3 - 24
						QC 3 - 61
						QC 3 - 81
160	Powdercoat - 1 White GI(A)- B4B	50 pcs	11/4/19	0.00	0.47	Powdercoat - 1 - B4B
						Powdercoat - 2 - B4B
						Powdercoat - 3 - B4B
						Powdercoat - 4 - B4B
170	QC 3	50 pcs	11/4/19	0.00	0.00	QC 3 - 10
						QC 3 - 13
						QC 3 - 15
						QC 3 - 17
						QC 3 - 18
						QC 3 - 2
						QC 3 - 28
						QC 3 - 3
						QC 3 - 30
						QC 3 - 34
						QC 3 - 36
						QC 3 - 41
						QC 3 - 51
						QC 3 - 58
						QC 3 - 59
						QC 3 - 68
						QC 3 - 9
						QC 3 - 40
						QC 3 - 19
						QC 3 - 43
						QC 3 - 24
						QC 3 - 61
						QC 3 - 81
180	Packaging 3-1 - Stock - B4B	50 pcs	11/4/19	0.00	0.00	Packaging 3 - 1 - B4B
						Packaging 3 - 2 - B4B

Plex 9/20/19 9:11 AM Dart.Renwick.Jennifer

DAS

74

9-89

OCT 04 2019

				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	51522
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	50 pcs	11/4/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

OCT 04 2019

Part Op 110 - (Purchasing) Issue P/O to Metec : HBOVSS6 Machine as per dwg C of C is required
 Descriptions: 120 - (Receive & Inspect for Damage & Mat'l Certs) Ensure C of C is attach

130 - (QC6- All purchased or subcontracted products)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC3- Inspect Part Finish)

160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____

FINISH TIME: _____

170 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - QC21- Final Inspection - Work Order Release)

x50 *A huo* 23 SEPT 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	3.4150 ft (.0683 ea)	110-Purchasing	5187667
D3235-1P	Lug	50 pcs (1 ea)	110-Purchasing	5216663

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	3	421	0
	D3235-1P	50	0	0

Part Specifications

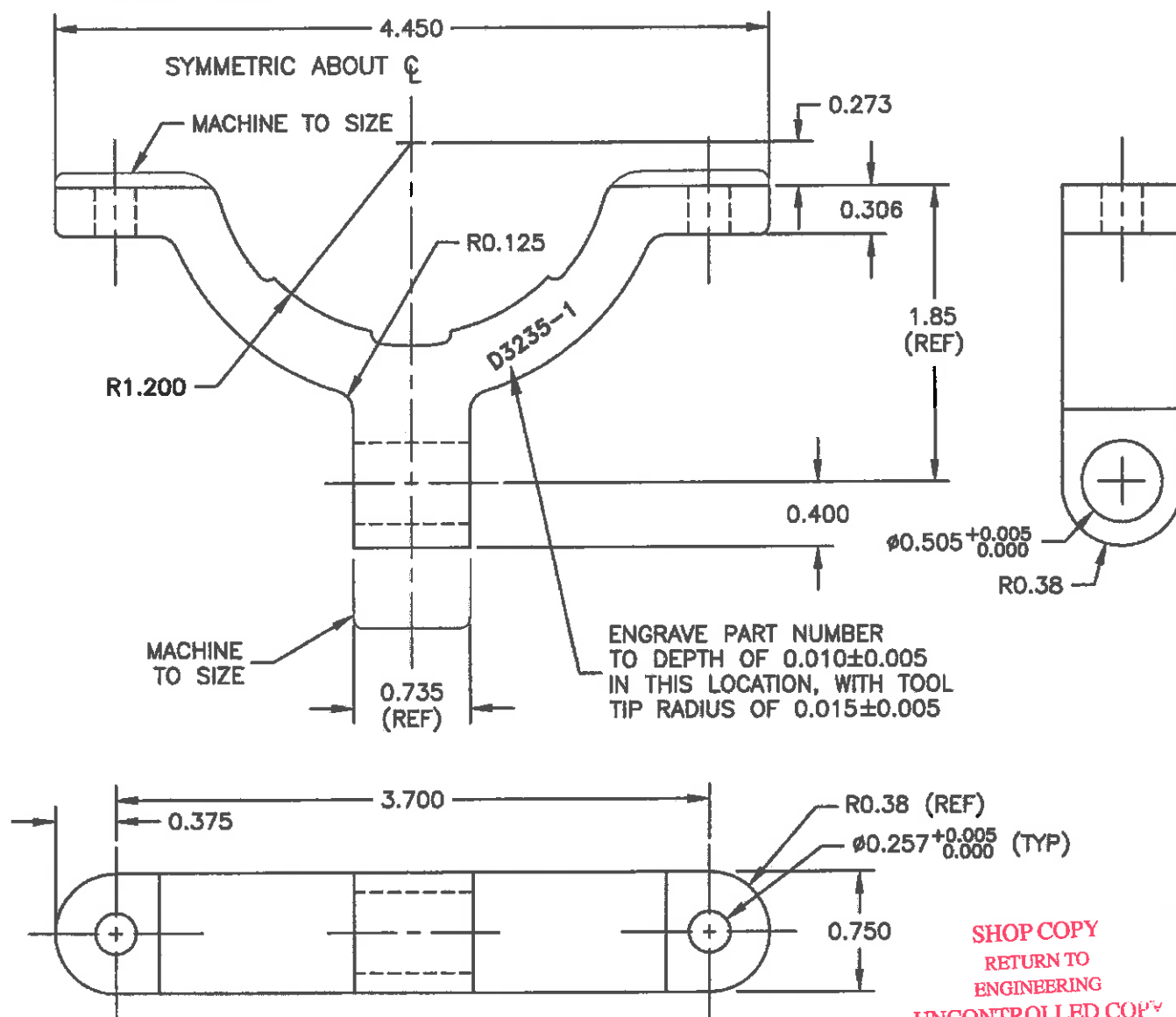
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Log	4.450inches ± 0.010	4.460 4.440		
2	Mounting Log	0.306inches ± 0.010	0.316 0.296		
3	Mounting Log	1.850inches ± 0.030	1.880 1.820		
4	Mounting Log	1.200inches ± 0.010	1.210 1.190		
5	Mounting Log	0.125inches ± 0.010	0.135 0.115		
6	Mounting Log	0.400inches ± 0.010	0.410 0.390		
7	Mounting Log	0.735inches ± 0.030	0.765 0.705		
8	Mounting Log	0.505inches + 0.005 - 0.000	0.510 0.505		
9	Mounting Log	0.380inches ± 0.030	0.410 0.350		
10	Mounting Log	3.700inches ± 0.005	3.705 3.695		
11	Mounting Log	0.375inches ± 0.010	0.385 0.365		
12	Mounting Log	0.750inches ± 0.010	0.760 0.740		
13	Mounting Log	0.257inches + 0.005 - 0.000	0.262 0.257		
14	Mounting Log	0.380inches ± 0.030	0.410 0.350		

Plex 9/20/19 9:11 AM Dart.Renwick.Jennifer



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
040405



D3235-1 MOUNTING LUG

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 200976

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS					
Job: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Eng. (Non-AW) ☐	Engineering ☐		
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Water Jet ☐		
	Use-as-is ☐	Large Fab ☐	Finishing ☐	Rec/Store/Packaging ☐	Supplier ☐		
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042) ☐			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY					
		Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
		Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐		
		Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐		
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐				
Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐				
Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐					
Other/Details: _____							
		Completed By _____					
		Lead hand / Supervisor _____					
		QC / QA Coordinator _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044556



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044556

PO Date: 9/23/19

Due Date: 10/14/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	200976	D3235-1P			Lug : Various STC's As Per Dwg D3235 Rev. A Alodine and Paint as per QS 1005	Firmed	-	10/14/19	50 pcs	0 pcs	50 pcs	\$16.20/pcs	\$810.00
						X50		SEP 24 2019					DP
2	200971	D2230-3P			Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QSI005	Firmed	-	10/14/19	100 pcs	0 pcs	100 pcs	\$14.90/pcs	\$1,490.00
						X100		SEP 24 2019					DP
Grand Total:													\$2,300.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 9/23/19 9:56 AM dart.lussier.patrick

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 25865
Shipment Date: 23-Sep-2019
Ship Via: Pick up at METEC
Order Number: 4224
Order Date: 09/23/2019

Customer Code: DART
Phone: (613) 632-9577
PO Number: POHB044556
Terms: Net 60 Days

Quantity						Description	Revision	Job Number
Item	Open	Shipped	B/O	Canceled	Unit			
1	50	50	0	0	EA	DART-D3235-1P Mounting Lug alodined and painted as per QSI 005	A	4224-01
2	100	100	0	0	EA	DART-D2230-3P Mounting Lug alodined and painted as per QSI005	G	4224-02

RECEIVED

SEP 24 2019

DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
50	D3235-1	Mounting Lug	A	S187667	020404-1	HB044556
100	D2230-3	Mounting Lug	G	S141186	020123-1	HB044556

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, September 23, 2019